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IS 9697 (1980): Bobbin cases for sewing machines with rotating hooks for industrial use [MED 29: Sewing Machines]

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“Knowledge is such a treasure which cannot be stolen”

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UDC 687·053·372

IS : 9697-1980

Indian Standard

(Reaffirmed 2006)

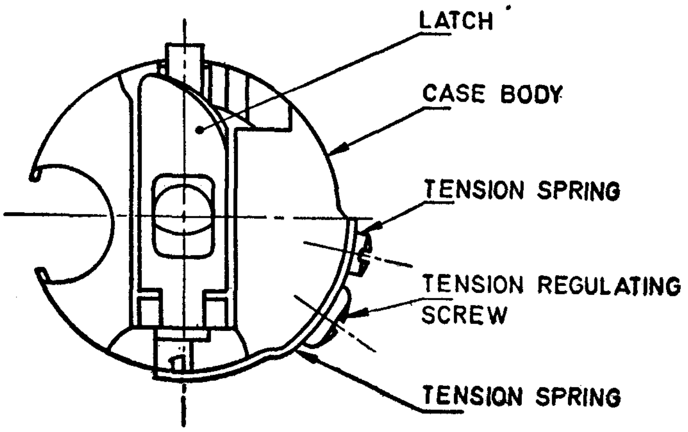
SPECIFICATION FOR BOBBIN CASES FOR SEWING MACHINES WITH ROTATING HOOKS FOR INDUSTRIAL USE

Sewing Machines Sectional Committee, EDC 34; Industrial Sewing Machines Subcommittee, EDC 34 : 2 [Ref : Doc : EDC 34 (3325)]

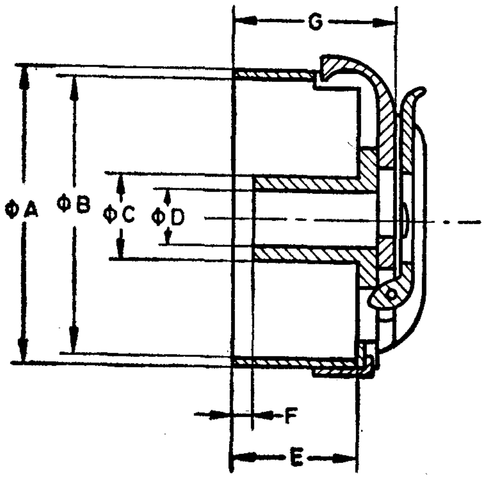
1. Scope — Covers the requirements for rotating hook bobbin cases mainly used in LS 1 (I) and LS 2 (I) class sewing machines for industrial use.

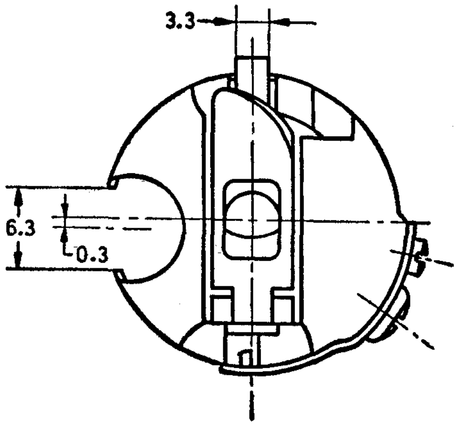
Note — Symbols LS 1 (*I*) and LS 2 (*I*) conform to IS 9152-1979 'Glossary of terms and identification symbols relating to classification of industrial sewing machines'.

2. Nomenclature



3. Dimensions





All dimensions in millimetres.

Dimensions	*A*	*B*	*C*	*D*	*E*	*F*	*G*
Maximum	22·5	21.5	5.95	4.45	9.4	1.3	11.8
Minimum	22·3	21·3	5·85	4·4	9·22	1·1	11·6

Adopted 23 December 1980

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[redacted] Gr 2

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4. Material and Hardness

4.1 The rotating hook bobbin case body and latch shall be manufactured from steel suitably heat-treated to have a minimum hardness of 400 *HV* with 5 kgf load [*see* IS : 1501 - 1968 Method for Vickers hardness test for steel (*first revision*)].

4.2 The thread tension spring for rotating hook bobbin case shall be manufactured from spring steel having a minimum hardness of 300 *HV* with 5 kgf load (*see* IS : 1501 - 1968).

5. Workmanship and Finish

5.1 The surfaces of the part in movable contact with each other and the threadway shall be finished smoothly.

5.2 The assembly of each part on the bobbin case shall be accurate, and shall function satisfactorily.

5.3 The fit of bobbin (*see* IS : 8892 - 1978 Bobbins for sewing machines with rotating hooks for industrial use) in bobbin case shall be satisfactory, and shall rotate smoothly.

5.4 The rotating hook bobbin case latch shall function satisfactorily when bobbin is put into the bobbin case.

5.5 Bobbin thread tension shall be uniform.

5.6 The bobbin case shall be well finished and free from blemish, pits, cracks, stains and rust, etc.

6. Marking — The bobbin case shall be marked on the body with manufacturer's name/initials or recognized trade-mark, if required.

7. ISI Certification Marking — Details available with the Indian Standards Institution.

8. Packing

8.1 Each bobbin case shall be given a suitable antirust coating or shall be wrapped in vapour phase inhibitor paper (commonly known as VPI paper). The wrapped bobbin cases shall then be securely packed in accordance with the best prevalent trade practice.

8.2 Each packing shall bear the manufacturer's name, trade-mark and description of the contents.

9. Sampling

9.1 Unless otherwise agreed to between the supplier and the purchaser, the sampling plan as given in Appendix A shall be followed. For further information reference may be made to IS : 2500 (Part I) - 1973 'Sampling inspection tables : Part I Inspection by attributes and by count of defects'.

APPENDIX A

(*Clause* 9.1)

SCALE OF SAMPLING AND CRITERIA FOR CONFORMITY

A-1. SCALE OF SAMPLING

A-1.1 *Lot* — In any consignment all bobbin cases manufactured from the same material under essentially similar conditions shall be grouped together to constitute a lot.

A-1.2 For ascertaining the conformity of the lot to the requirements of the specification, tests shall be carried out for each lot separately. The number of bobbin cases to be selected at random for this purpose shall be in accordance with col 1 and 2 of Table 1. To ensure the randomness of selection, IS : 4905-1968 'Methods for random sampling' shall be used.

TABLE 1 SCALE OF SAMPLING AND PERMISSIBLE NUMBER OF DEFECTIVES

Number of Bobbin Cases in the Lot	For Dimensions, Workmanship and Finish		Sample Size for Hardness
	Sample Size	Permissible No. of Defectives*	
(1)	(2)	(3)	(4)
UP to 25	5	0	3
26 ,, 50	8	0	3
51 ,, 100	13	0	5
101 ,, 150	20	1	5
151 ,, 300	32	1	8
301 ,, 500	50	2	8
501 ,, 1000	80	3	13
1001 and above	125	5	13

*This ensures that lots containing only 1·5 percent or less defectives will be accepted most of the time.

A-2. NUMBER OF TESTS AND CRITERIA FOR CONFORMITY

A-2.1 The bobbin cases selected according to **A-1.2** shall be examined for dimensions (*see* **3**), workmanship and finish (*see* **5**). If the number of bobbin cases failing to meet one or more of the requirements mentioned above is less than or equal to the permissible number of defectives given in col 3 of Table 1, the lot shall be declared as conforming to the requirements of these characteristics.

A-2.2 In the case of these lots which have been found satisfactory according to **A-2.1**, a number of bobbin cases equal to the sample size indicated in col 4 of Table 1, shall be subjected to test for hardness (*see* **4**). Any bobbin case failing to meet the requirements for hardnesses shall be considered to be defective.

A-2.2.1 If no defectives are found among the bobbin cases subjected to hardness tests (*see* **A-2.2**), the lot shall be declared as conforming to the requirements of the specification, otherwise not.

EXPLANATORY NOTE

While preparing this standard assistance has been derived from JIS B 9074-1964 Bobbin cases for sewing machines for industrial use, issued by Japanese Industrial Standards Committee.

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